

Work Order ID 57739

April 14, 2010 11:35:23 AM



Page 1

Item ID: D3296-1

Accept



Setup Start



Revision ID:

Item Name: Door Panel

Stop



Start Date: 14/04/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 22/04/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

PL

Date:

10-4-14

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3296 | Rev A | | | | | | | | |

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3296
Deburr if necessary

☐ Dwg Rev:

A

☐ Prog Rev:

A

☐ 2-

2024 .063

B10-4-19

(16)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B10-4-19

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

5/10/04/20

(45)

PD →

| W/O: 57739 | | WORK ORDER CHANGES | | | | | |
|------------|------|---------------------------------------|----|---------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| 10/4/20 | #120 | Took Q4 x1 for QC inspection template | S | 10/4/20 | x1 | | S 10/04/20 |
| | | | | | | | |

Part No: D3296-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 57739

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Page 2

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Cust Item ID:

Required Date: 22/04/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| 130 | Small Fab | 0.00 | | | | | | | |
| | Small Fab | 0.00 | | | | | | | |
| | Memo | | | | | | | | |
| | Debur | | | | | | | | |
| 140 | Chemical Conversion Coat per QSI005 4.1 | 0.00 | | | | | | | |
| | HandFinish | 0.00 | | | | | | | |
| | Memo | | | | | | | | |
| | Hand Finishing | | | | | | | | |
| 150 | QC3- Inspect Part Finish | 0.00 | | | | | | | |
| | QC | 0.00 | | | | | | | |
| | Memo | | | | | | | | |
| | Quality Control | | | | | | | | |

0.00

0.00

0.00

0.00

0.00

0.00

7 m-l 10/04/20

~~7 m-l 10/04/20~~

7 m-l 10/04/20

10/04/20

15X

15X

15

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Work Order ID 57739

April 14, 2010 11:35:23 AM



Page 3

Item ID: D3296-1

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Setup Start



Revision ID:

Item Name: Door Panel

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Start Date: 14/04/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 22/04/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Identify as per dwg & Stock Location: ST-186

0.00



Packaging

Memo

0.00

Packaging

15

MF 10-4-23

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/23 MF

MF 10-4-23

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Picklist Print

April 14, 2010 11:35:27 AM

Page 1

Work Order ID: 57739

Parent Item: D3296-1

Parent Item Name: Door Panel

Comments: IPP C05.10.14 Added step 14 KJ/EC
IPP Rev:D Now on Waterjet 06-11-02 JLM

Start Date: 14/04/2010

Required Date: 22/04/2010

Start Qty: 10.00

Required Qty: 10.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| M2024T3S.063 | | Purchased | No | | | 100 | sf | 260.0000 | 6.9432 | 11.2 | | |



2024-T3 .063 sheet



18.10-4+19

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT22

260

111787

2

113866

24

113867

42

114351

192

113867

16

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Sheet 1 of 1

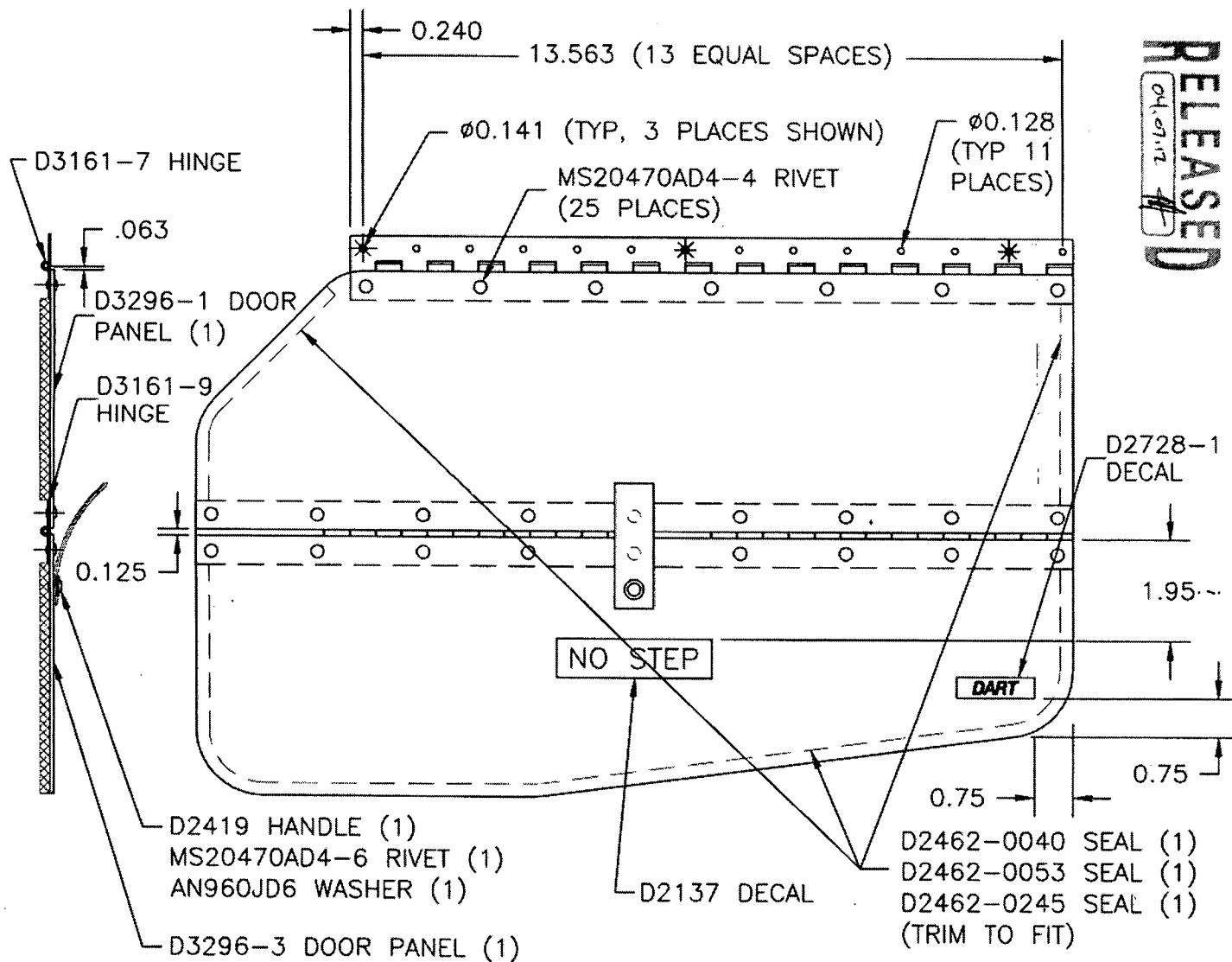
ENGINEER: J. A.

UNCON
SUBJEC
WITHOUT INSTITUTE
WORK ORDER
NO. 67739



RELEASED
04.07.12

| | | | | |
|---------|-------------|-----------|---------------|---|
| DESIGN | DART | DRAWN BY | DART | DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA |
| CHECKED | [Signature] | APPROVED | [Signature] | DRAWING NO. D3296 |
| DATE | 04.06.28 | TITLE | DOOR ASSEMBLY | REV. A 1 OF 2 |
| A | 04.06.28 | NEW ISSUE | | SCALE 1:3 |



D3296-041 DOOR ASSEMBLY

- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

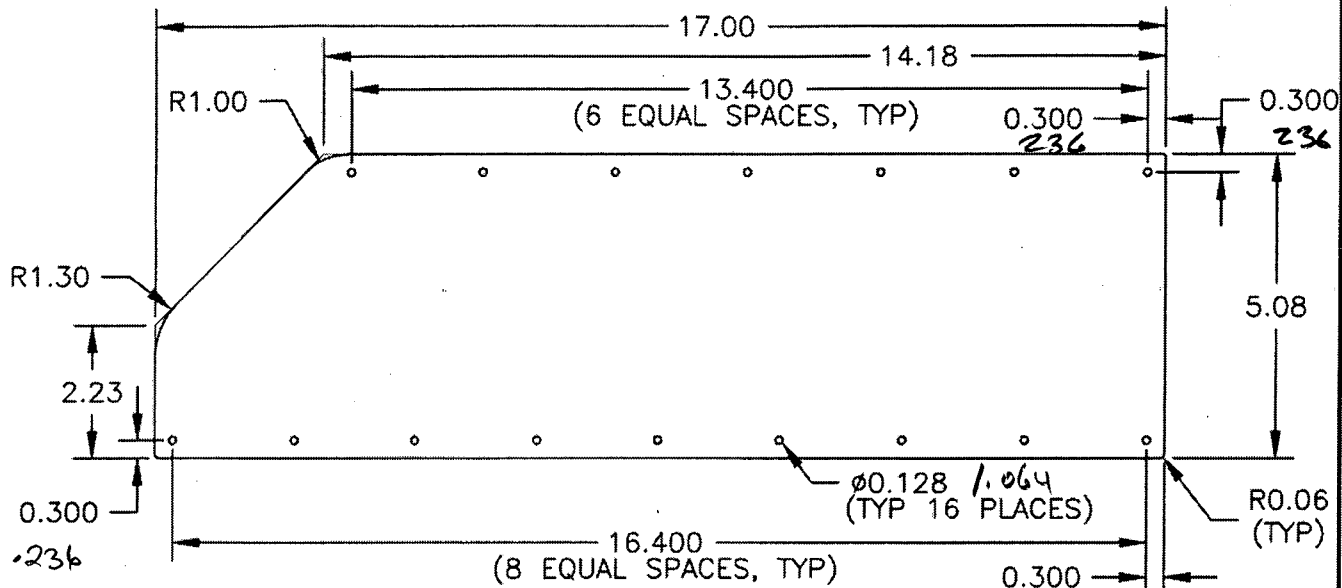
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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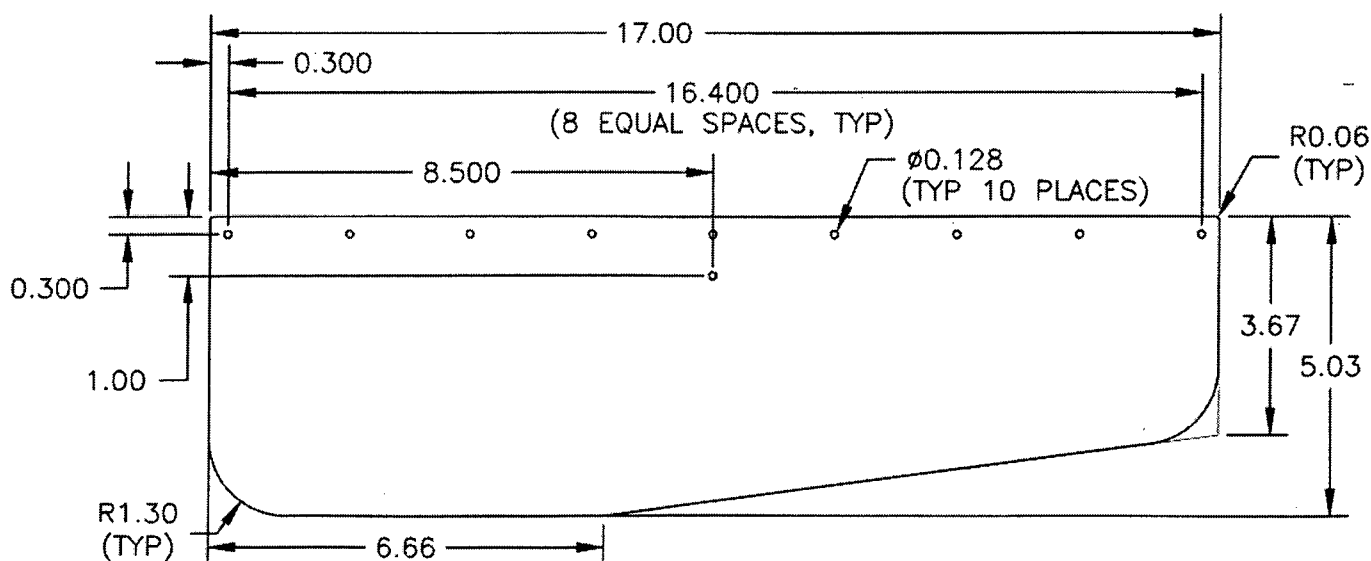


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|---------------------|-----------------------|---|------------------|
| DESIGN <i>UP</i> | DRAWN BY <i>UP</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>#</i> | APPROVED <i>#</i> | DRAWING NO. D3296 | REV. A 2 OF 2 |
| DATE 04.06.28 | | TITLE DOOR ASSEMBLY | SCALE 1:3 |

w/o 57739



D3296-1 DOOR PANEL



D3296-3 DOOR PANEL

D3296-1 AND D3296-3

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK
(REF DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
04.07.12

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